

Work Order ID 54685

December 16, 2009 10:46:05 AM



Page 2

Item ID: D3891-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Fwd LH

Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

=> 808/12/16

④

130



Small Fab

Small Fab

Memo

Deburr if necessary

0.00

0.00

E509/12/17 ②

140



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

80 02/12/17 ①

Work Order ID 54685

December 16, 2009 10:46:06 AM



Page 3

Item ID:	D3891-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Panel, Fwd LH					
Start Date:	12/16/09	Start Qty:	1.00		Cust Item ID:	
Required Date:	12/18/09	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Small Fab	0.00							
	Small Fab								
	Memo	0.00							
	1 - Bond gasket to smooth side of panel as per dwg								
	A/R 3M 1300 adhesive Batch: 17113174								
160 	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
	Quality Control								
170 	Identify as per dwg & Stock Location:	0.00							
	Packaging	0.00							
	Packaging								

8/30/12/17 (1)

27 8/12/18

(1)

9/12/18 SP (1)

SLAN
HAI

Work Order ID 54685

December 16, 2009 10:46:06 AM



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Item ID: D3891-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Fwd LH

Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/21

M/09-12-18
①

Picklist Print

December 16, 2009 10:46:04 AM

Page 1

Work Order ID: 54685

Parent Item: D3891-041

Parent Item Name: Panel, Fwd LH


Start Date: 12/16/09

Required Date: 12/18/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,011.175	4.9011			
												
GE PLASTICS LEXAN SHEET												

HB 9-12-16

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

2011.175198

103106

1.6765

105330

47.8767

109455

40.5717

111710

329.893632

112585

1591.15667

D3891-3

Manufactured No

140

Each

0.0000

1.0000



Gasket

B 54689

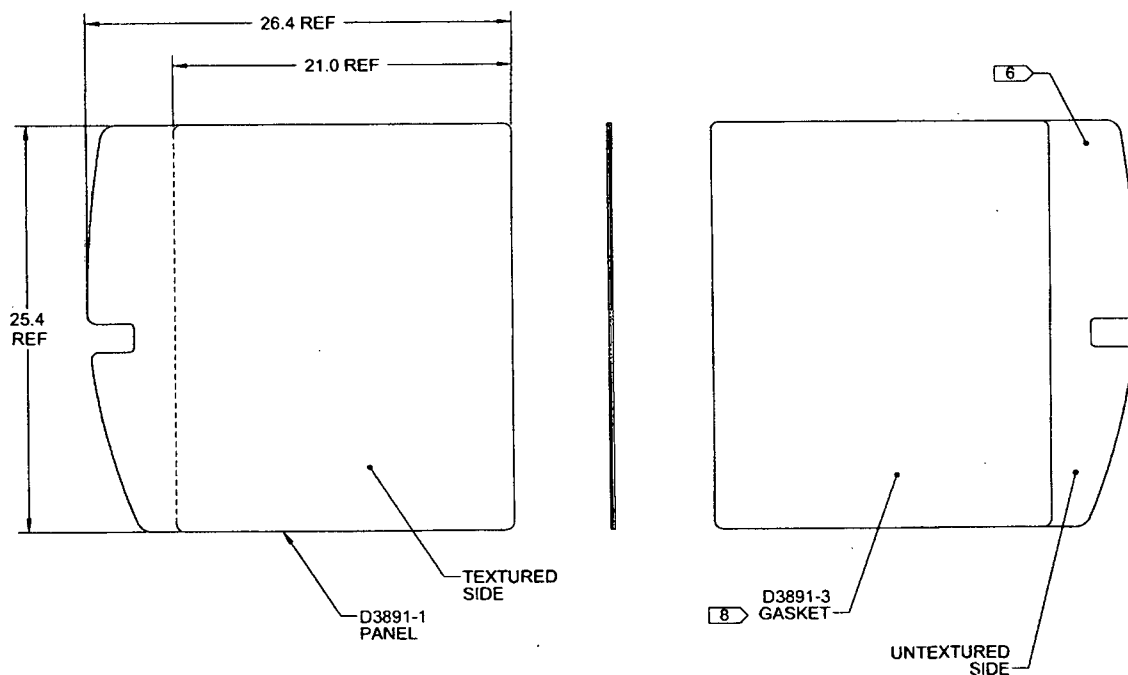
112585

88 09/12/12

①

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE

**D3891-041 PANEL, FWD LH**

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
 - 7) WEIGHT: 3.67 lbs
 - 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54685

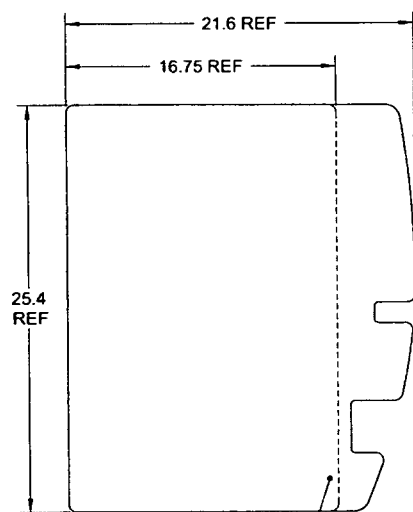
BT 09-12-16

RELEASED
C9/06/16 NV

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JP</i>	DRAWING NO.	REV. A
CHECKED	<i>JP</i>	D3891	SHEET 1 OF 6
MFG. APPR.	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	PANEL, FWD	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

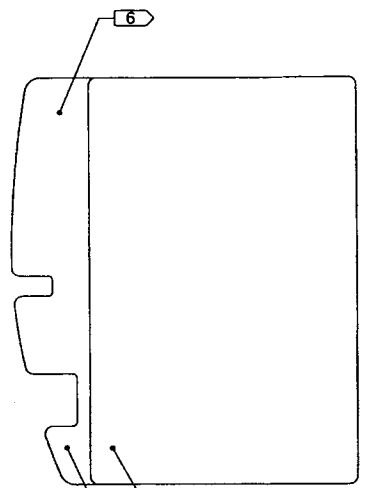
PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-042	PANEL, FWD RH
2	1	D3891-2	PANEL
3	1	D3891-4	GASKET
4	A/R	3M 1300	ADHESIVE

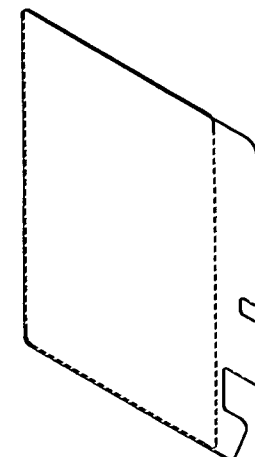


D3891-2 PANEL

TEXTURED SIDE

D3891-042 PANEL, FWD RH

D3891-4 GASKET [8]

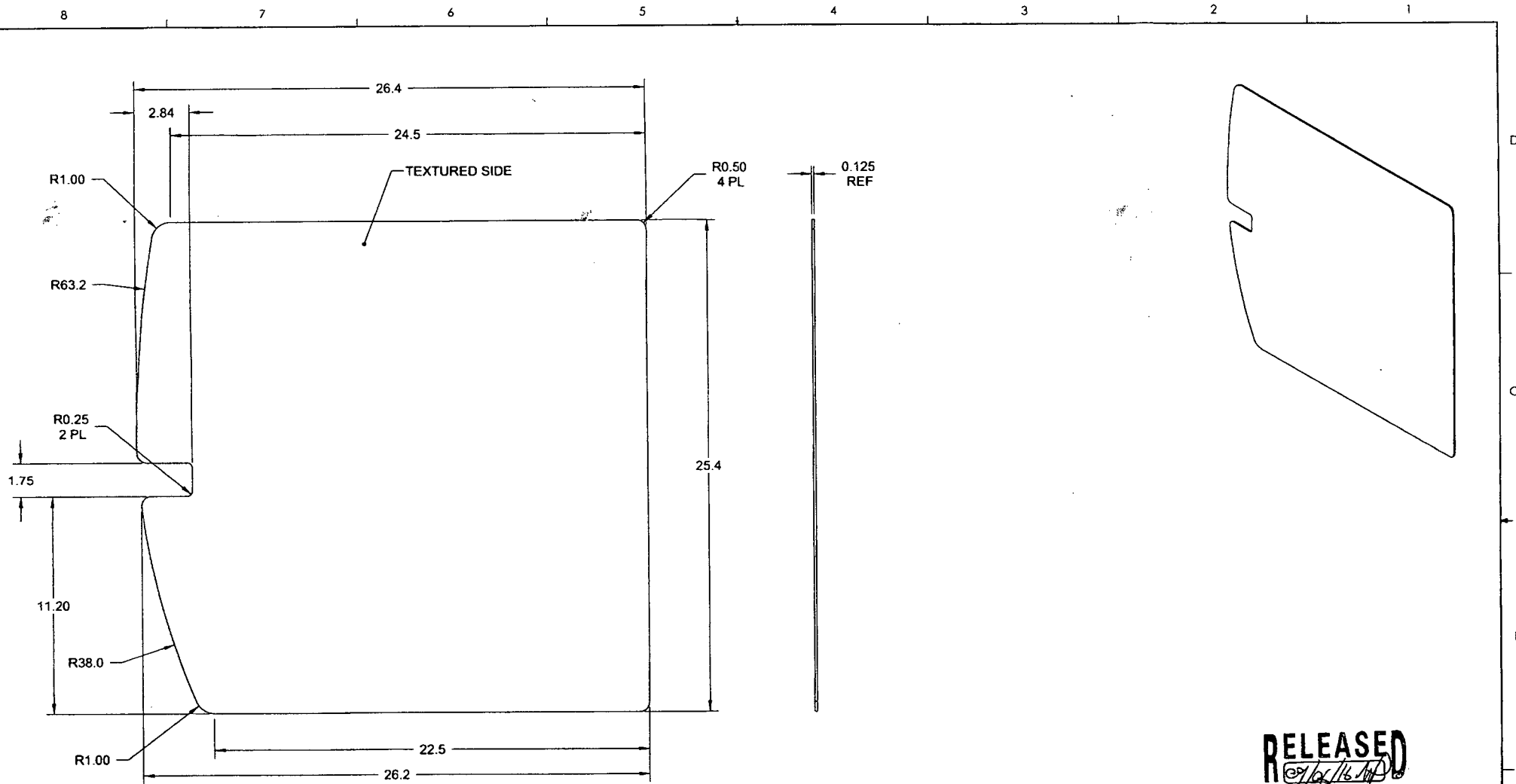
UNTEXTURED
SIDE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.93 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

RELEASED
C918/14 W

DESIGN	gp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	gp		
CHECKED	RE	DRAWING NO.	REV. A
MFG. APPR.	RE	D3891	SHEET 2 OF 6
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DE APPR.	RE	PANEL, FWD	NTS
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D3891-1 PANEL

NOTES:

1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

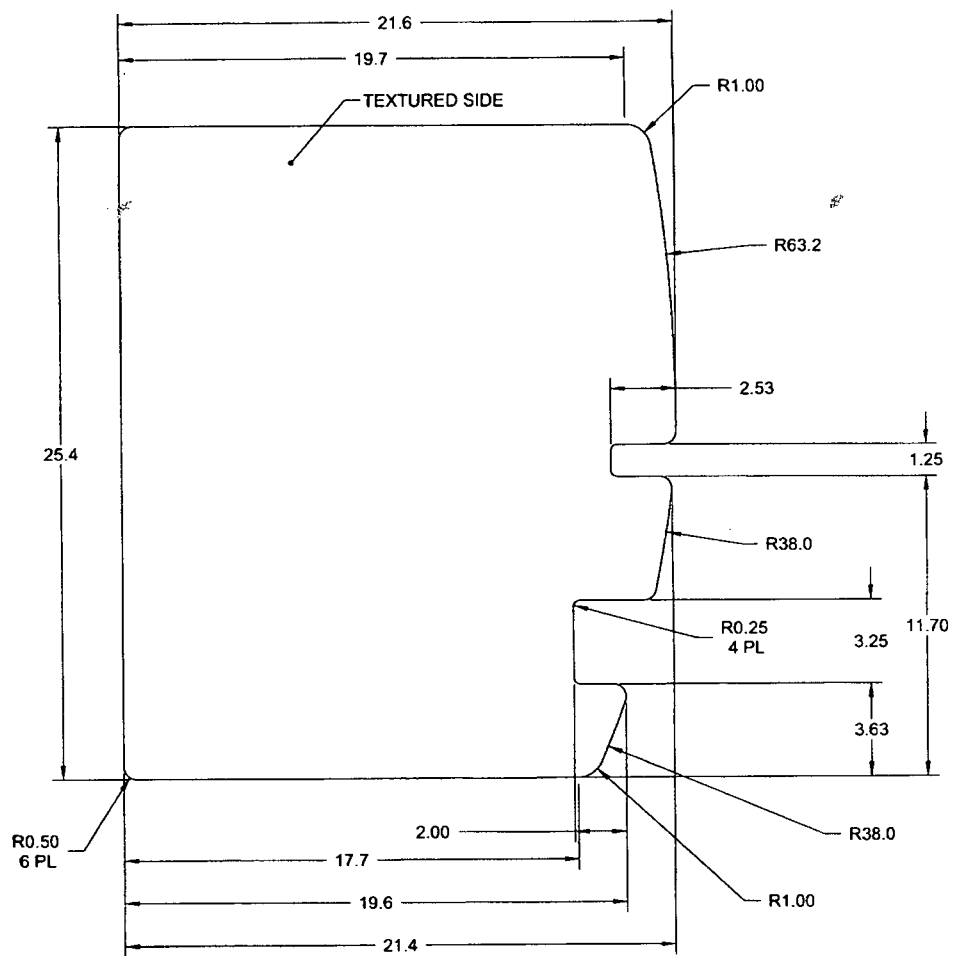
6) IDENTIFICATION: NONE

7) WEIGHT: 3.46 lbs

RELEASED
07/06/16

DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	GP		
CHECKED	DP	DRAWING NO.	REV. A
MFG. APPR.	DP	D3891	SHEET 3 OF 6
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	PANEL, FWD	NTS
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W/B 54685



D3891-2 PANEL

NOTES:

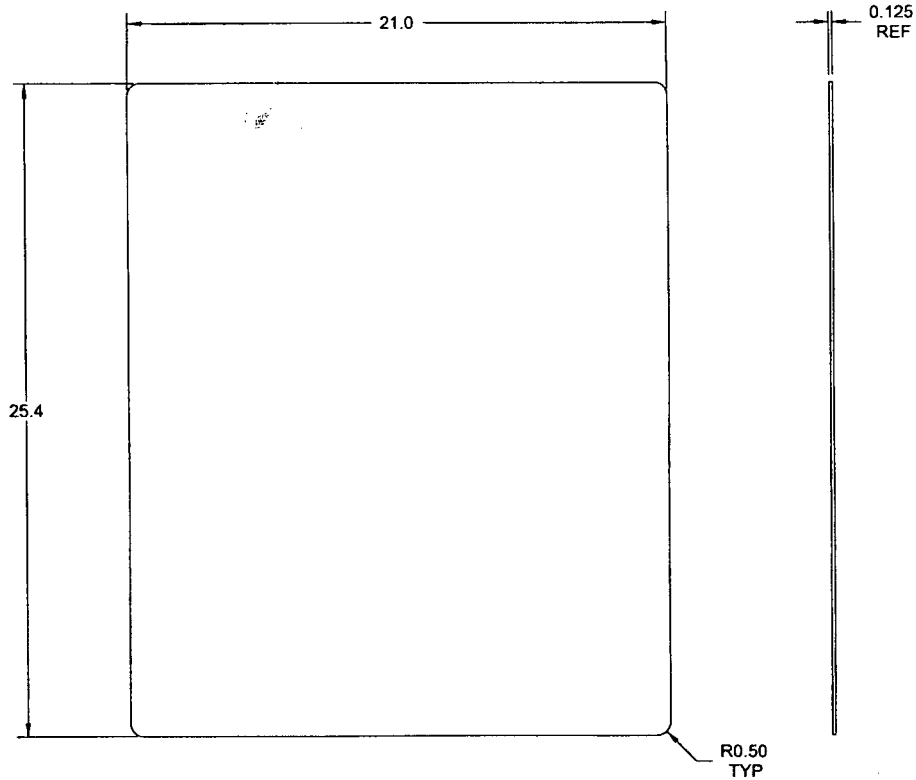
- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.77 lbs

RELEASED
09/05/01

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DRAWN	DP		
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	MP	D3891	SHEET 4 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	PANEL, FWD	NTS
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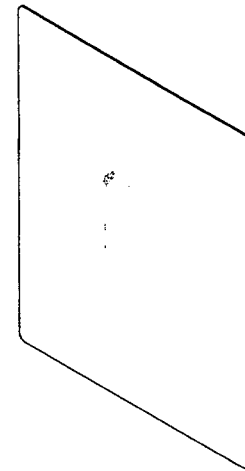
8 7 6 5 4 3 2 1



D3891-3 GASKET

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.21 lbs



D

C

B

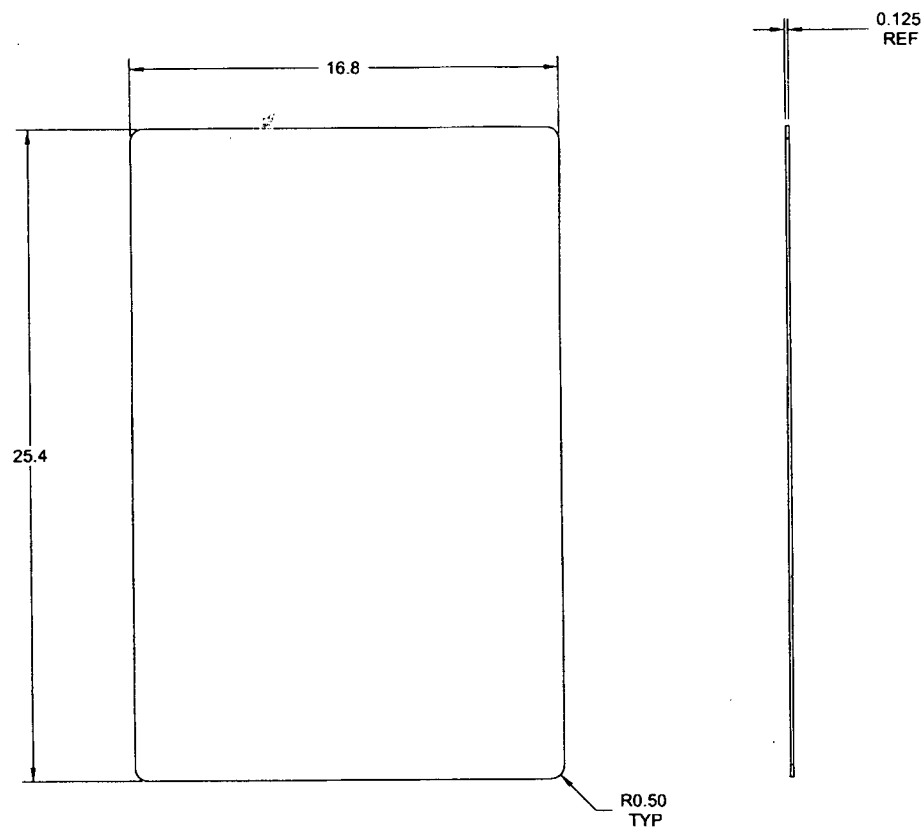
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09/06/16

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CHECKED	90	DRAWING NO.	REV. A
MFG. APPR.	90	D3891	SHEET 5 OF 6
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8 7 6 5 4 3 2 1



D3891-4 GASKET

RELEASED
09/08/16

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	94	D3891	SHEET 6 OF 6
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